

Work Order ID: 64107

Wednesday, November 24, 2010 1:10:59 PM



Page 1

Item ID: D3913-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Rib					
Start Date: 11/24/2010	Start Qty: 3.00		Cust Item ID:		
Required Date: 11/30/2010	Req'd Qty: 3.00		Customer:		
Reference:					

Approvals:	Process Plan: <u> H </u>	Date: <u>10-11-24</u>	Tooling:	Date:	Run	Start	
	QC: <u> </u>	Date: <u> </u>	SPC (Y/N): <u> </u>	Date: <u> </u>		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3913	A

100		0.00							
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D3913 2- remove identification marks and deburr								

SAD 10-12-06

(3)

110		0.00							
QC	QC - Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

SA 10.12.06 / 10/12/06

(3)

120		0.00							
Packaging	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00							

SAD 10-12-08

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 64107

Wednesday, November 24, 2010 1:10:59 PM

Page 2

Item ID: D3913-3

Accept

Revision ID:

Item Name: Rib

Start Date: 11/24/2010 Start Qty: 3.00

Required Date: 11/30/2010 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/08 *[Signature]*
Bl 10128
(3)

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NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 1:11:03 PM

Page 1

Work Order ID: 64107

Parent Item: D3913-3

Parent Item Name: Rib



Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.750W.049

Purchased

No

100

f

143.9182

8

25.26316



304 SQ Tube .75x.75x.049W



SAD 10-12-06

Location

Loc Qty

Loc Code

MAT

12.68976794

113763

0

114323

12.6897189

114677

0.00001

114835

0.000039

MAT017

3.68448E-05

114298

3.6845E-05

WA

131.2284

114992

31.9125

115260

99.3159

8.27211

m116319

16.8422

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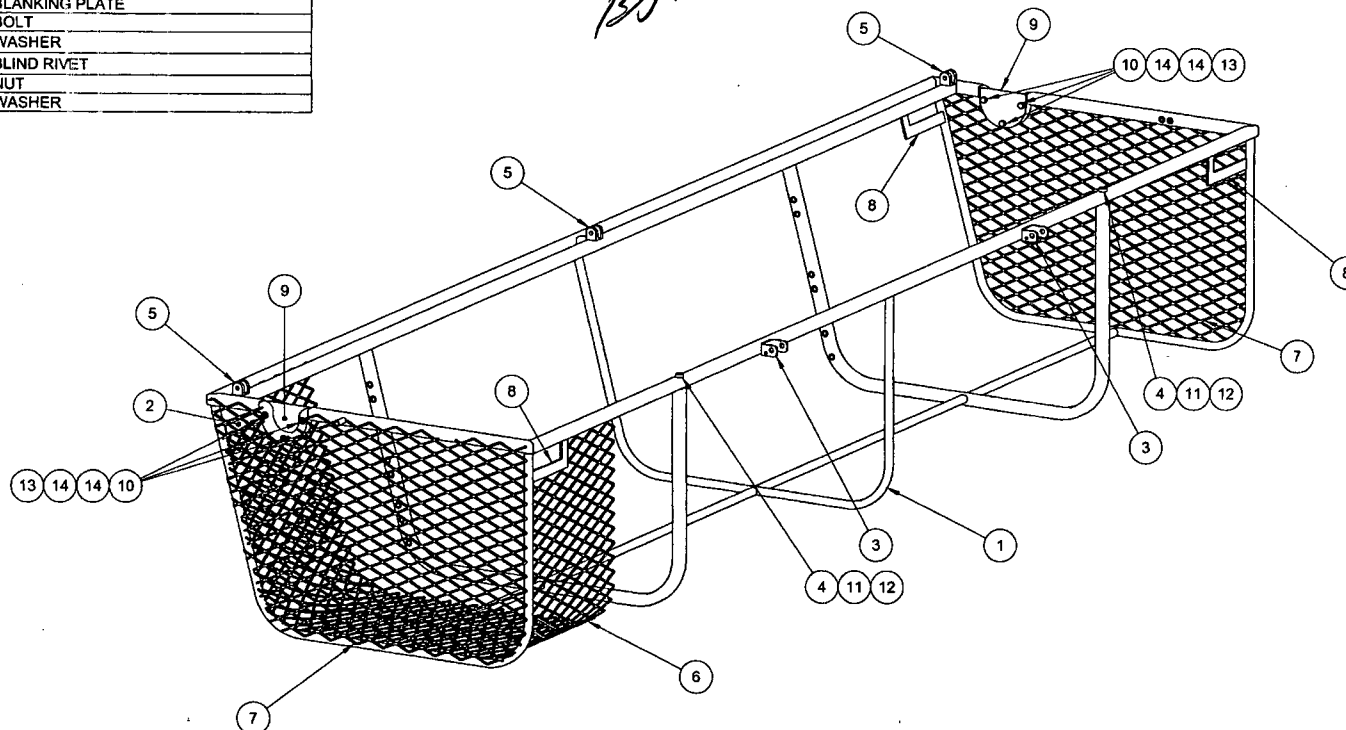
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 RETURN TO
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 64107
BS 10-11-24

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
 (MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
 2010-03-22
WTP

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A
 SHEET 1 OF 6

TITLE **LONG BASKET BASE ASSY (350)** SCALE NTS

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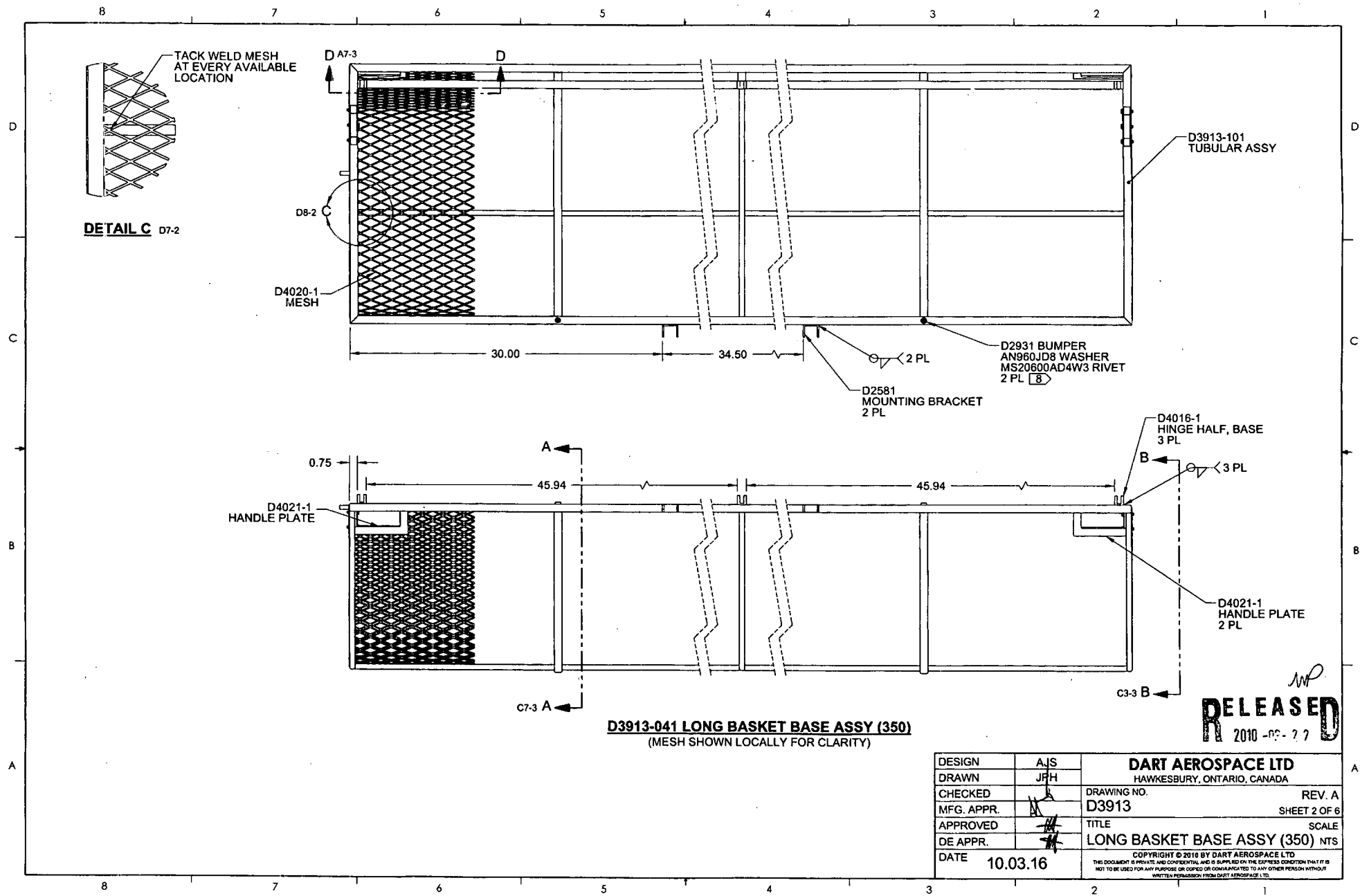
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NOTE: Date & initial all entries

W6 64107



RELEASED
2010-05-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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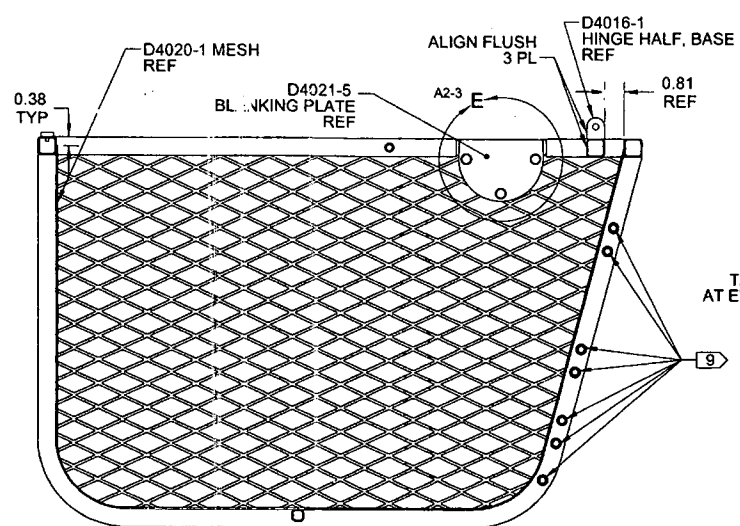
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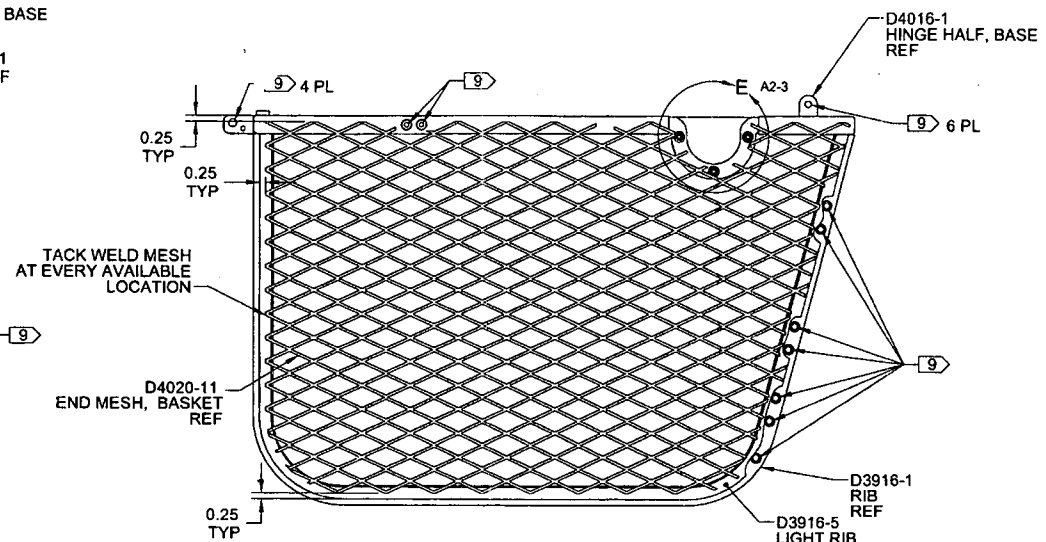
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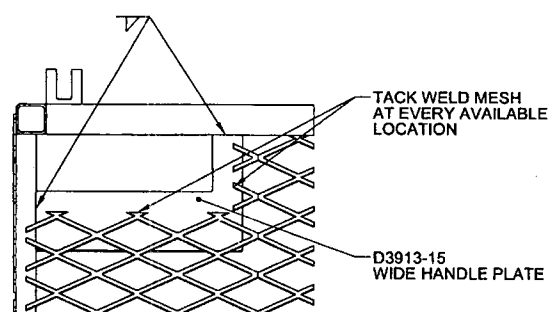
W/O 64107



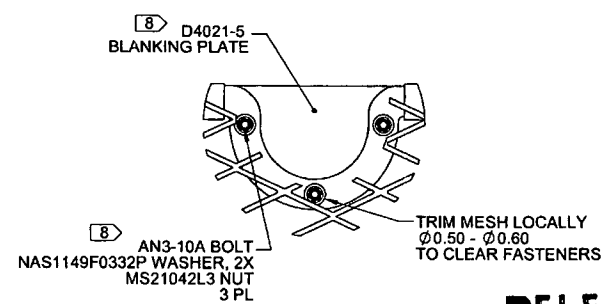
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D2-3
D6-3

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2010-03-22

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DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
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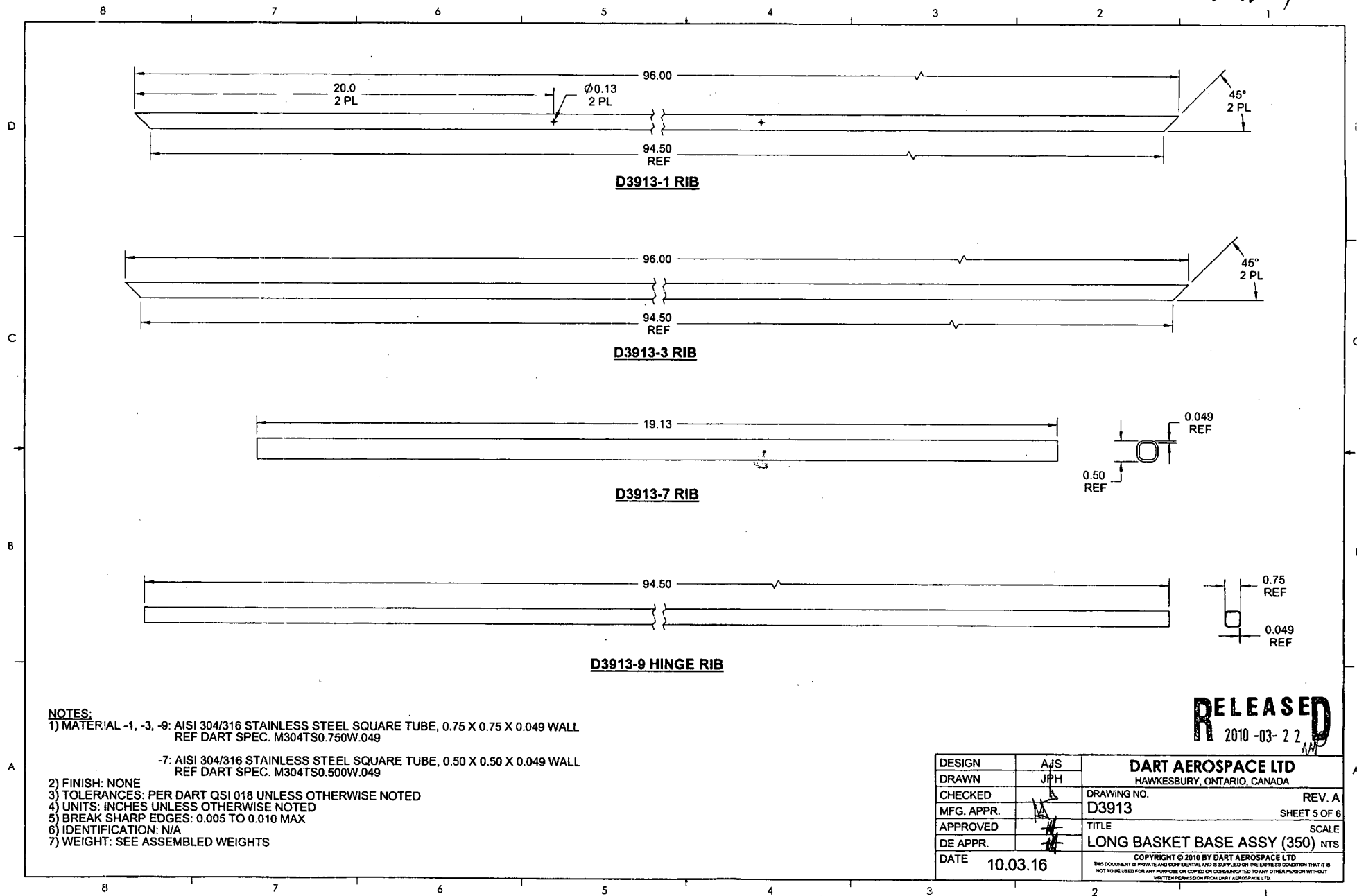
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ULO 64107



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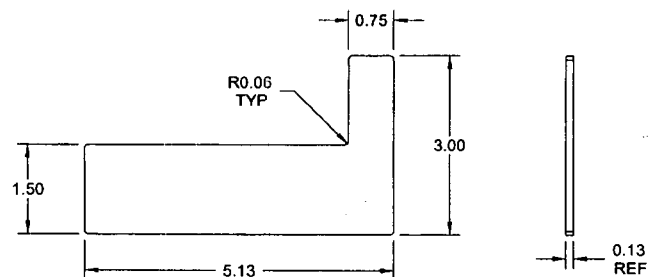
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w/o 64107



D3913-15 WIDE HANDLE PLATE

NOTES

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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2010-03-22

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DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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